

Date: Tuesday, 16/09/2008 1:22:15 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 42027		
Estimate Number	: 10713		
P.O. Number	:	Part Number	: D3213041
This Issue	: 16/09/2008 S.O. No. :	Drawing Number	: D3213 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 38894	Material	:
Written By	:	Due Date	: 30/09/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.9.16</u>		
Comment	: Est Rev:A New Issue 05-11-17 17:27		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31613	Hinge 15.0"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
2	D3161-3	Hinge	<u>B22103</u>

50

2.0	D32131	Door Panel
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-1	Door	<u>B42104</u>

54

3.0	D32133	Door Panel
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
1	D3213-3	Door	<u>B42105</u>

54

4.0	MS20470AD44	Rivet, Universal Head
-----	-------------	-----------------------



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Assembly Kit

Qty	Part Number	Description	Batch
24	MS20470AD4-4	Rivet	<u>M109545</u>

8/10/30

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 16/09/2008 1:22:15 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 42027

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3213 Identify as D3213-041

FF 08/11/06

(10)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/06 (10)

7.0

POWDER COATING

POWDER COATING



M 105642



(10X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:30  
320 °C  
8:00

M-L 08/11/07

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-07

(10)

9.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2137 Decal

108012

54

10.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2419 Handle

108012

(5)

B42100

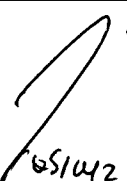
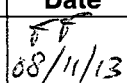


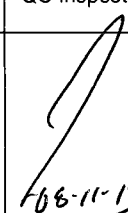


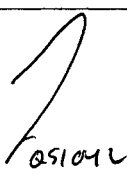
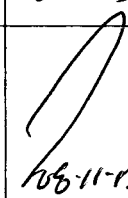
8/10/30

(10X)

54

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3213-041 PAR #: N/A Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 1A Date: 08-11-17  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>42027</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/11/13	15	<del>One</del> rivet was cracked at the riveting hole were enlarged		Pick & replace the rivet with a MS20470 AOS-6 M9619 Qty 1 open hole to accommodate the rivet.	 08/11/13	 06-11-13	 05/04/12	 06-11-13
		R.C. Part moved during the pressing of the rivet.		part was too damaged to re-install the rivet. part did not look good. Scrap 7 part.		 06-11-13	 05/04/12	 06-11-13

NOTE: Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 42027

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2462

Seal



Comment: Qty.: 2.4000 f(s)/Unit Total: 24.0000 f(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

2 D2462

Seal

~~1537747~~  
B37747

50

12.0

D27281

Dart Logo Label - small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 D2728-1

Decal

B39012

50

13.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 AN960JD6 Washer

M6685

50

14.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description

Batch

1 MS20470AD4-6

Rivet

M108377

8/10/13

(10x)

50

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3213

8/08/13 (9) FF

100

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/08/11/13

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOOR ASSEMBLY

Job Number: 42027

Part Number: D3213041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



(9x)

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 210

6/4/13

80

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/14 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED	APPROVED	DRAWING NO.	REV. A
<i>[Signature]</i>	<i>[Signature]</i>	D3213	1 OF 2
DATE	TITLE		SCALE
03.09.03	DOOR ASSEMBLY		1:3
A	03.09.03	NEW ISSUE	

03 01 15

D3161-3 HINGE (2 PLACES)

.063

D3213-1 DOOR PANEL (1)

0.197

14.607 (14 EQUAL SPACES)

$\phi 0.128$  (TYP 12 PLACES)

$\phi 0.141$  (TYP, 3 PLACES SHOWN)

MS20470AD4-4 RIVET (24 PLACES)

D2137 DECAL

0.125

NO STEP

2.00

D2728-1 DECAL

DART

0.75

0.75

D2419 HANDLE (1)

S20470AD4-6 RIVET (1)

N960JD6 WASHER (1)

D2462-0034 SEAL (2)

D2462-0210 SEAL (1) (TRIM TO FIT)

UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

ENGINEERING  
RETURN TO  
SHOP COPY

UNCONTROLLED C  
SUBJECT TO AMENDM  
WITHOUT NOTICE  
WORK ORDER

ENGINEERING  
RETURN TO  
SHOP COPY  
2419 HANDLE (1)  
S20470AD4-6 RIVET (1)  
N960JD6 WASHER (1)  
D3213-3 DOOR PANEL (1)

D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE  
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

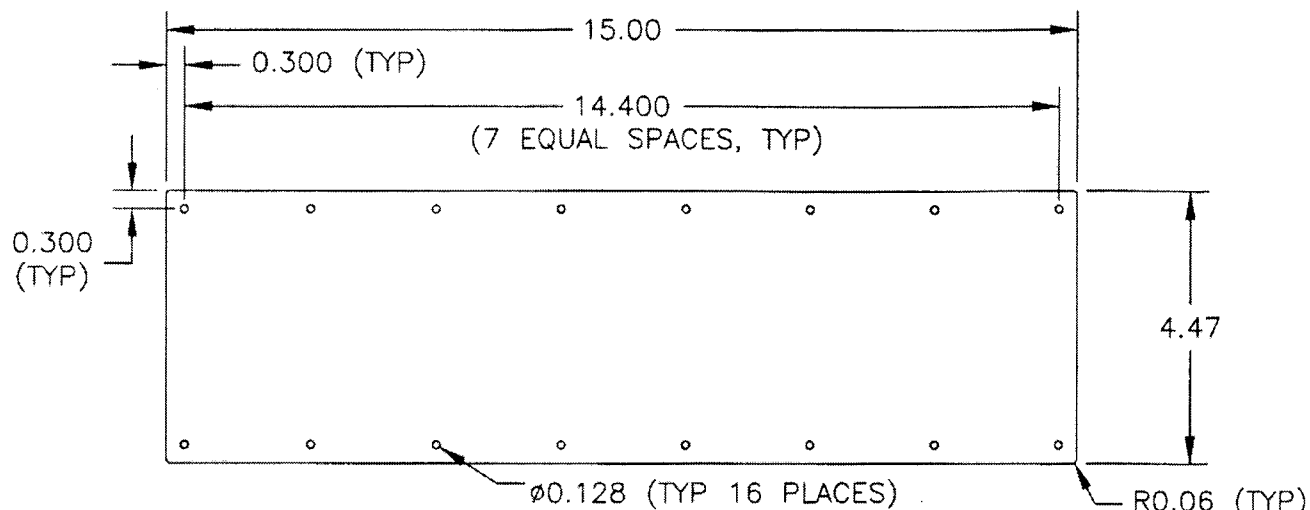
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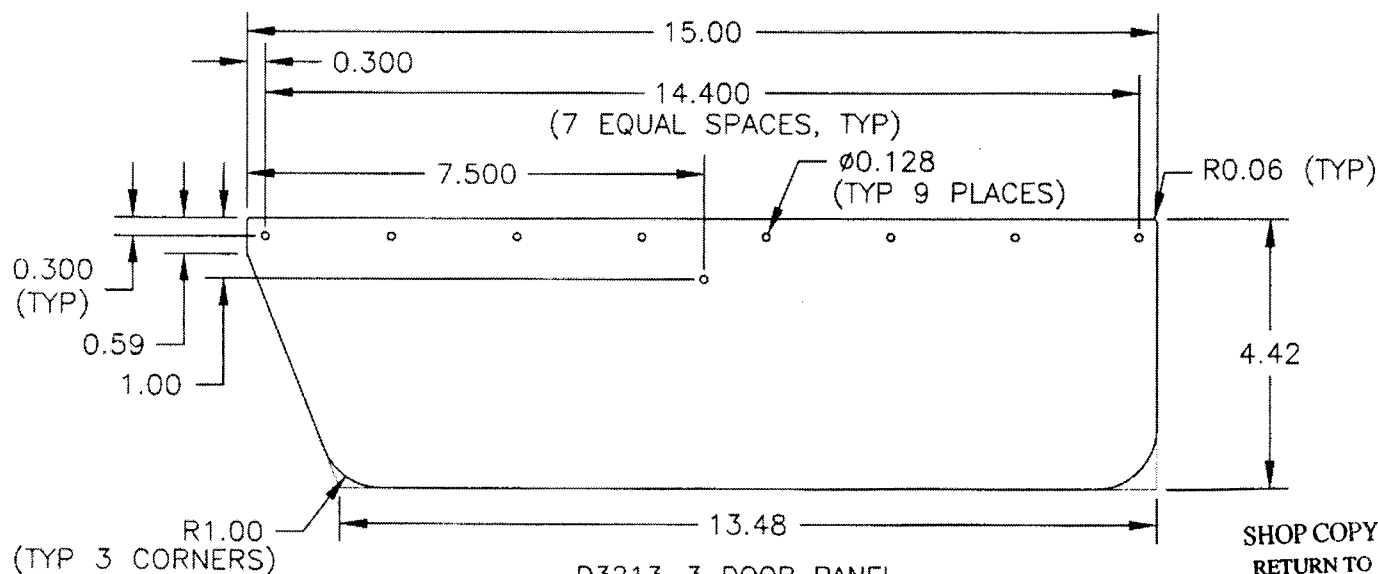
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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